

Work Order ID 70472

Thursday, June 09, 2011 8:29:53 AM

Item ID: D3609-1

Revision ID:

Item Name: Doubler

Start Date: 6/9/2011 Start Qty: 6.00

Required Date: 6/10/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3609

Rev B

100



Waterjet

FLOW CNC Waterjet

364-032

FLOW WATER JET

Memo

1-Cut as per Draw D3609

Draw Rev

Prog Rev

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine F A/TALB

Memo

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

0.00

0.00

0.00

0.00

0.00

B11-6-10

B11-6-10

8610610

H6

Work Order ID 70472

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Item ID: D3609-1

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Start Date: 6/9/2011 Start Qty: 6.00

Required Date: 6/10/2011 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

121

Form as per dwg

0.00



Brake NC

Memo

0.00

SPB 11/06/10

(2)

Brake NC

USE DT9760 TOOL

122

0.00



Small Fab

Memo

0.00

SPB 11/06/10

(2)

Small Fab

1- TRIM AS PER DWG USING GUIDELINES

123

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SPB 11/06/10

(x2)

Quality Control

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Item ID: D3609-1

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location

0.00

Memo

1 B70471

0.00

10/11/6/10

2

140



QC

Quality Control

QC24- Final Inspection - Work Order Release

0.00

Memo

USE DT9760 TOOL

0.00

OK 11/06/10

MF
11-06-10

Checklist Print

Thursday, June 09, 2011 8:30:00 AM

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Work Order ID: 70472



Parent Item: D3609-1

Parent Item Name: Doubler

Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev.B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C
 AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	71.2600	1.1769	7.433053			



304/316 032 Sheet



HB 11-6-10

Location	Loc Qty	Loc Code
020	7	
109057	7	
MAT020	64.26	
117379	64.26	

117379

(6)

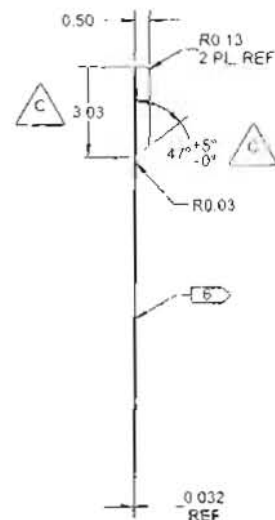
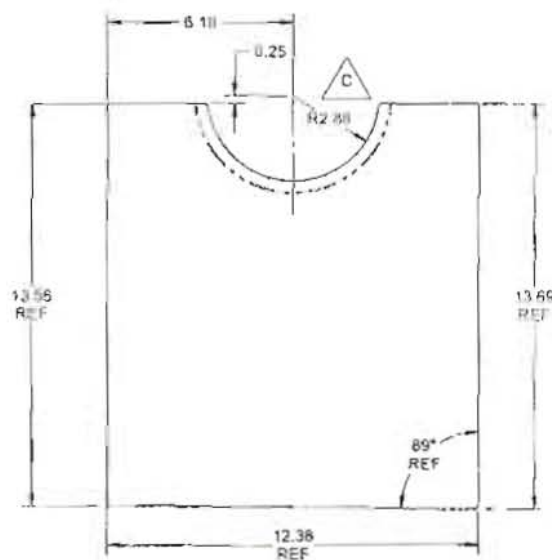
Work Order: 70472

Part Number: 13609-1

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X	First Article	X	Prototype
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Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3609-1 DOUBLER

NOTES:

- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART Q&I 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER Q&I 044 & 1
- 7) WEIGHT: 1.46 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

W/6 70772

RELEASED
2011-06-09

2.88 WAS 2.88 (ZN C5-1); 3.63 WAS 3.20 (ZN C4-1); ADD ANGLE TOLERANCE (ZN C3-1); REVISE D3609-1F	RF	11.06.07	
ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.06.28	
NEW ISSUE	MF	07.04.11	
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR			
APPROVED			
DE APPR			
DATE	11.06.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO: **D3609**

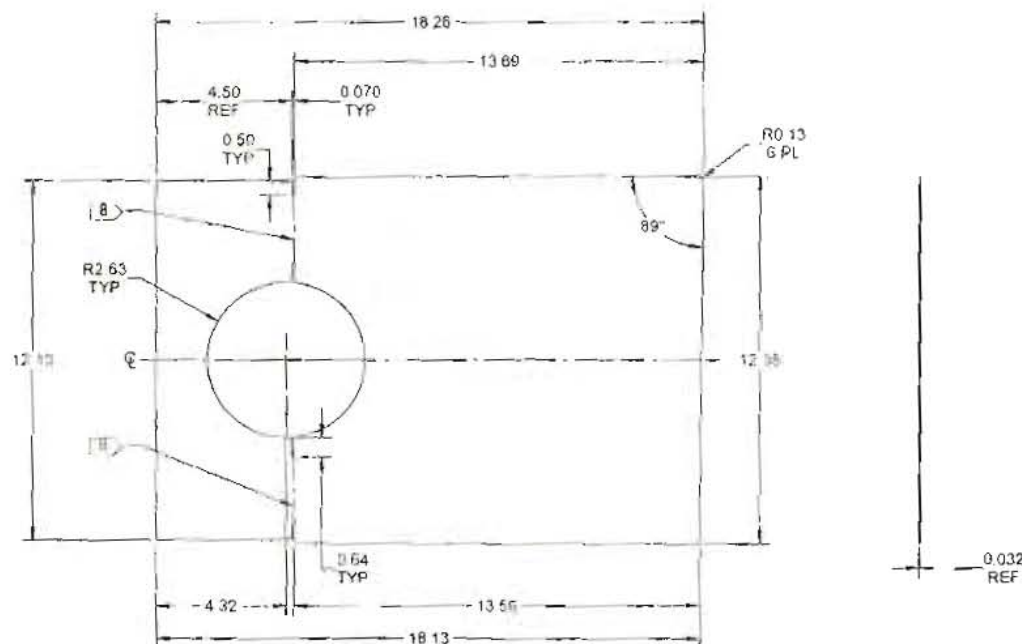
TITLE: **DOUBLER**

REVISION: **REV. C**

SHEET 1 OF 2

SCALE: **NTS**

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D3609-1F FLAT PATTERN \triangle

NOTES

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 32 GAUGE
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM 240
 OR ASME SA240
 PER DART SPEC M304S22GA

2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.87 lbs

Wto part

RELEASED
 2011-06-09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV C
MFG APPR		D3609	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DATE	11.06.07	DOUBLER	DTG